

# Work Order ID 64133

Thursday, November 25, 2010 10:24:10 AM

Page 1

Item ID: D3542-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 11/25/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-1-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3542

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 4.0" long

B.A 10/12/22

12

Ø

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA684 Rev: A & Dwg D3542 Rev: A □2-Deburr per dwg D3443

B.A 10/12/22

12

Ø

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 10/12/22

12

Ø

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Page 2

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

\*\*\*\*\*ENSURE TO MASK INSIDE BORE\*\*\*\*\* START TIME:  
10:20 OVEN TEMPERATURE 320° FINISH  
TIME: 10:50.

aml 10/12/23

12 0

12 BR 10-12-23.

12 BR 10-12-23.

# Work Order ID 64133

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Item ID: D3542-1

Accept

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Item Name: Bracket

Start Date: 11/25/2010 Start Qty: 12.00

Required Date: 11/30/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

= 2 M

10/01/03

12

1

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 248

0.00

Packaging

Memo

0.00

Packaging

11/01/03 (12)

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

CK 11/01/03  
CZ 11/01/03

# Picklist Print

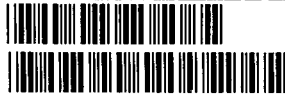
Thursday, November 25, 2010 10:24:16 AM

Page 1

Work Order ID: 64133

Parent Item: D3542-1

Parent Item Name: Bracket



Start Date: 11/25/2010

Required Date: 11/30/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: A New Issue 07-04-23 JLM  
IPP Rev: B updated powder coat per NCR 07.05.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B30000X01.5 00		Purchased	No			100	f	23.1789	0.3333333	4			



6061-T6 Bar 3.00 x 1.50

Location

Loc Qty

Loc Code

MAT

23.1789

109058

11.4926

114468

11.6863

4.0500 ft B.A 10/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

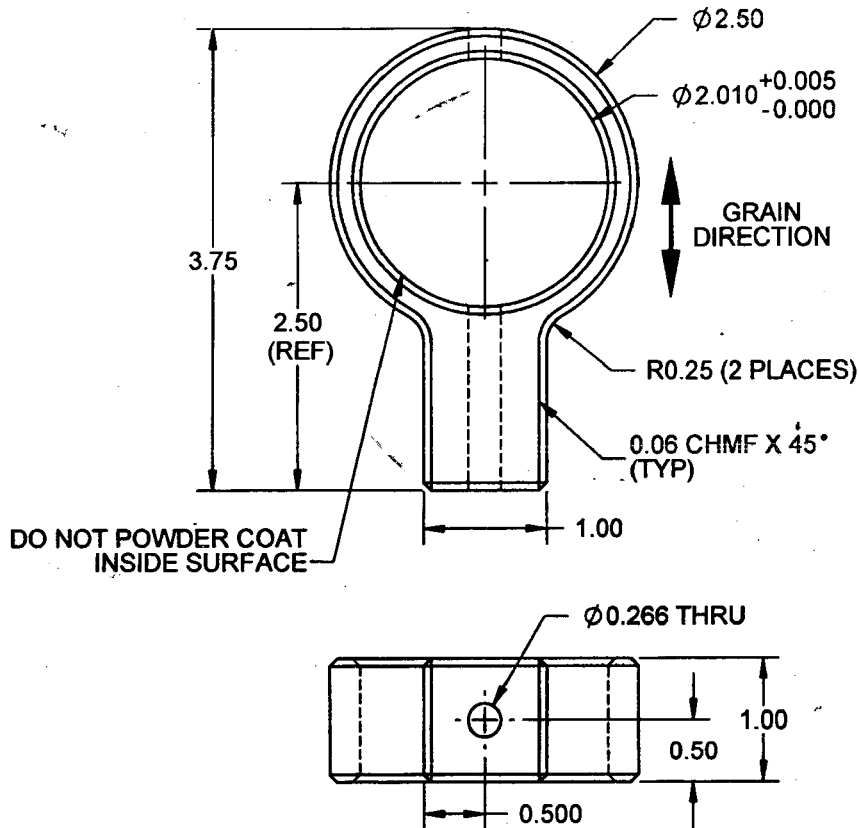
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

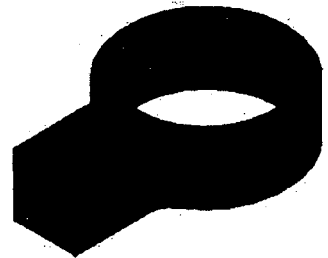


**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3542	REV. A SHEET 1 OF 1
DATE 06.11.27	TITLE BRACKET		SCALE 2:3
REV A	DATE 06.11.27	DESCRIPTION NEW ISSUE	

**RELEASED**  
07 04 02

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *44133*  
*10/11/25*

**D3542-1 BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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